



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7401
Job Sheet 186052



Part No: 647.7401

Job Qty: 1 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

1057

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Stores/Pkg-1		DAS 6 DEC 18 2018
110	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging1-1		DAS 6 DEC 18 2018
120	Small Fab	1 pcs	11/23/18	11/23/18	0.00	1.09	Small Fab-1		DAS 6 DEC 18 2018
130	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		DAS 6 DEC 18 2018
140	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		DAS 6 DEC 18 2018
150	QC21-SA	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21		DAS 6 DEC 18 2018

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE
Descriptions: 598: _____ exp. date: _____

140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	2 Ea (2 ea)	90-Start up Operation	5105905
647.7610	Upper Deflector	1 Ea (1 ea)	90-Start up Operation	5138533
647.7810	Bracket A	1 Ea (1 ea)	90-Start up Operation	5084599
647.7811	Bracket B	1 Ea (1 ea)	90-Start up Operation	5114688
647.7812	Center Plate, Upper	1 Ea (1 ea)	90-Start up Operation	5032495
MS21042-3	Nut	3 Ea (3 ea)	90-Start up Operation	5132364
MS21042L08	Nut	13 Ea (13 ea)	90-Start up Operation	5100409
MS27039-08-19	Screw	6 Ea (6 ea)	90-Start up Operation	5104359
MS27039-08-23	Screw	7 Ea (7 ea)	90-Start up Operation	5031848
MS27039-1-19	Screw	3 Ea (3 ea)	90-Start up Operation	FM134134
NAS1149F0332P	Washer	6 Ea (6 ea)	90-Start up Operation	5132206
NAS1149FN832P	Washer	68 Ea (68 ea)	90-Start up Operation	5107796

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3015	2	44	0
	647.7610	1	1	0
	647.7810	1	49	0
	647.7811	1	51	0
	647.7812	1	3	0
	MS21042-3	3	241	0
	MS21042L08	13	1,682	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																																							
Pa		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐																																																																																																																																	
		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐																																																																																																																																	
NC		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐																																																																																																																																	
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Container No: S138438 Part: 647.7401 Job No: 186052 Serial No/ Batch: S138438 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____																																																																																																																																											
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MS27039-08-19	6	1,574	0
MS27039-08-23	7	30	0
MS27039-1-19	3	329	0
NAS1149F0332P	6	1,863	0
NAS1149FN832P	68	2,481	0

Part Specifications

Specifications could not be found.

Plex 11/9/18 8:05 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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